MODEL 550-1 AUTOLOADING RIFLE

(SEE ILLUSTRATION)

PRICE LIST

In ordering parts, specify model, caliber, part number, part name and serial number of your rifle. All parts marked with an asterisk (*) should be fitted at factory or by a qualified gunsmith.

Part No.	Part Name
254	Action Spring
417	Action Spring Bushing
253	Action Spring Guide
38	Action Spring Guide Retainer
18318W	*Barrel
18318Y	*Barrel (550-1P)
18895	Bolt
319	Bolt Assembly (includes Bolt, Extractor, Extractor Spring, Plunger and Firing Pin)
358	Bolt Handle
17378	Bolt Plate
17035	Bolt Plate Screw (2)
18185	Carrier
20403	Carrier Assembly Complete (includes Carrier and Bushing, Carrier Tension Spring, Cartridge Stop)
260	Carrier Spacer Bushing
18884	Carrier Tension Spring
18180	Cartridge Stop
18324	Cartridge Stop Detent
305	Cartridge Stop Detent Pin
18183	Cartridge Stop Detent Spring
263	Connector
264	Connector Pin
262	Connector Plunger
266	Connector Spring
454	Deflector
455	Deflector Screw
18318	Extractor
17667	Extractor Plunger
17573	Extractor Spring
20490	Firing Pin (includes Firing Pin and Firing Pin Rivet)
21076	Front Sight
129	Front Sight Ramp (550-1P)
130	Front Sight Ramp Screw (550-1P) (2)
97	Inner Magazine Tube
21080	Inner Magazine Tube Complete (includes Tube, Follower, Spring, Magazine Pin, Magazine Plug)
370	Magazine Follower
299	Magazine Pin
32	Magazine Plug
33	Magazine Ring
274	Magazine Screw
18379	Magazine Spring
35	Magazine Tube Support Screw
276	Main Spring
18311	Main Spring Plunger
17229	Open Sight Leaf
83	Outer Magazine Tube
531	Outer Magazine Tube Assembly Complete (includes Outer Magazine Tube, Magazine Screw, Receiver Insert, Receiver Insert Spacer, Receiver Insert Spacer Pin, Cartridge Stop Detent, Cartridge Stop Detent Pin, Cartridge Stop Detent Spring)
17021W	Rear Peep Sight Disc (550-1P) (Large Aperture)

Part No.	Part Name
17021Y	Rear Peep Sight Disc (550-1P) (Small Aperture)
550	Rear Peep Sight Assembly (550-1P) (includes Rear Peep Sight Disc, Large Hole; Rear Peep Sight Disc, Small Hole; Rear Peep Sight Nut, Rear Sight Base, Rear Sight Elevation Indicator, Rear Sight Elevation Plate, Rear Sight Elevation Plate Screw (2), Rear Sight Windage Plate, Rear Sight Windage Plate Screw (2), Rear Sight Base Screw)
439	Rear Peep Sight Nut (550-1P)
417	Rear Sight Base (550-1P)
17024	Rear Sight Base Screw (550-1P)
126	Rear Sight Elevation Indicator (550-1P)
127	Rear Sight Elevation Plate (550-1P)
17023	Rear Sight Elevation Plate Screw (550-1P) (2)
17370	Rear Sight Screw (2)
20730	Rear Sight Step
425	Rear Sight Windage Plate (550-1P)
17025	Rear Sight Windage Plate Screw (550-1P) (2)
20735	*Receiver Assembly (includes Receiver and Ejector)
20736	*Receiver Assembly (includes Receiver and Ejector) (550-1P)
17984	Receiver Insert
280	Receiver Insert Spacer
303	Receiver Insert Spacer Pin
282	Receiver Plug
283	Receiver Plug Retainer
284	Receiver Plug Retainer Screw
473	Receiver Plug Retainer Screw Lock Washer
18710	*Revolving Chamber
469	Safety
286	Safety Lever
243	Safety Screw
288	Sear (includes Sear and Bushing)
18711	Sear Pin
289	Sear Spring
290	Sear Spring Cam
291	Stock Assembly (includes Stock, Butt Plate, Butt Plate Screw (2), Take-Down Screw, Take-Down Screw Escutcheon, Trigger Guard, Trigger Guard Screw (2)
439	Stock Assembly (550-1P) (includes all component parts named above)
20703	Take-Down Screw
292	Take-Down Screw Bushing
17369	Take-Down Screw Escutcheon
293	Trigger
96	Trigger Guard
17377	Trigger Guard Screw (2)
68	Trigger Pin
300	Trigger Spring
438	Trigger Spring Plunger
18708	Trigger Stop Pin

INSTRUCTIONS FOR OPERATION AND CARE

of the

Remington

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MODEL 550-1

AUTOLOADING RIFLE

(Tubular Magazine)

Shoots .22 Short, Long, and Long Rifle Cartridges Interchangeably and Automatically without Adjustment

REMINGTON ARMS COMPANY, INC. Ilion, N.Y., U.S.A.

Form RD-5041 Rev. 8-54-49

INSTRUCTIONS FOR OPERATION AND CARE

This rifle is shipped from the factory in take-down condition, as in Figure 1.

FIGURE 1

Assemble Gun: Place barrel and receiver in stock with trigger projecting through stock into guard, push rearward until receiver is firmly seated against end of slot in stock; then, tighten take-down screw into receiver until barrel and receiver are drawn firmly in stock.

Load Magazine: Tubular magazine is located at bottom of barrel. Turn knurled magazine plug at front end of magazine, pull out until loading opening forward of stock is uncovered, insert cartridges, with front end of cartridge toward muzzle, until visible at opening. Close tube upon cartridges, rotating slightly for passing over shell head. Turn magazine plug to lock in closed position.

Load Gun: Grasp bolt handle, located on right side of receiver, and pull fully back. This motion causes carrier to raise cartridge. Release bolt handle *quickly* (do not ease bolt forward) to load first cartridge; gun is now ready to fire.

To Make Safe: Move safety lever rearward covering red dot on right side of receiver. This movement locks the trigger in position.

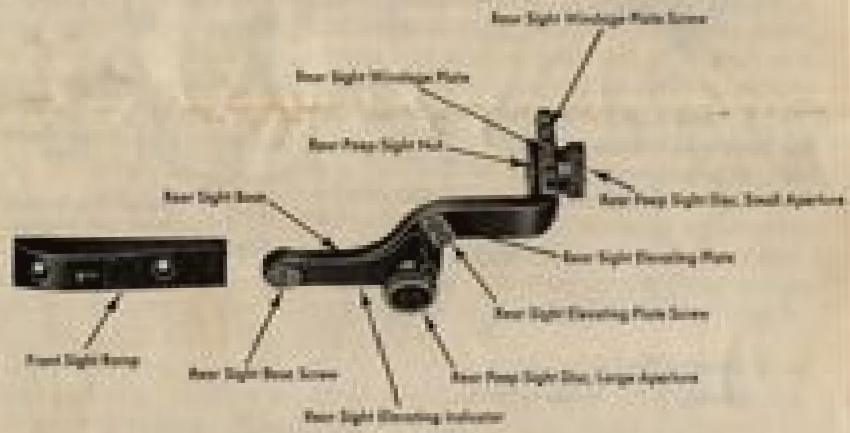
Fire: BE SURE GUN IS POINTED WHERE YOU WANT TO SHOOT. With action closed, push safety lever forward to "Off" position. Be sure deflector is fully rearward and deflector screw is tight. Pull trigger to fire.

Repeat: The trigger must be pulled for each shot. Pressure from the burning powder opens the bolt, ejects the empty shell, and reloads the barrel for the next shot until the magazine is empty.

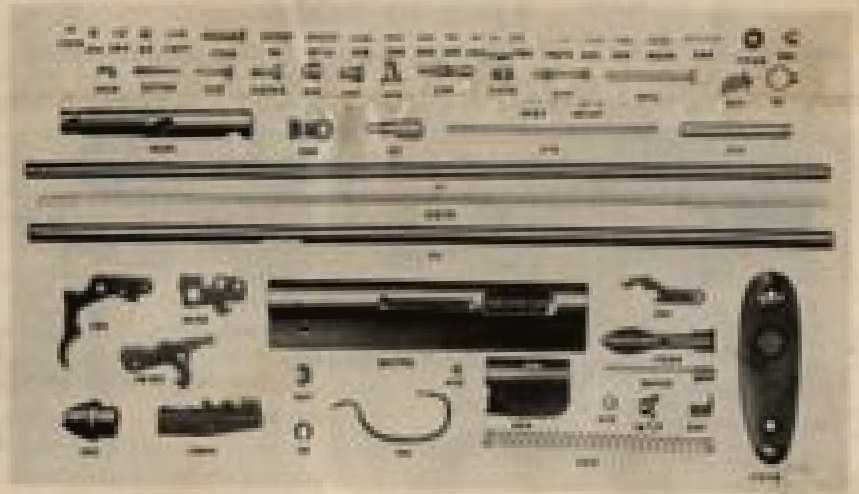
Unload Without Firing: Move safety lever rearward to "On" position. Completely remove magazine tube and tip gun to pour cartridges from end of magazine. Replace and lock tube. THERE ARE STILL TWO CARTRIDGES IN GUN. Pull back bolt handle ejecting cartridge in barrel. Close bolt which puts second cartridge in barrel and again pull back bolt handle to eject last shell. Always operate action several times to assure yourself that gun is entirely empty.

MODEL 550-1P

This is the same as 550-1 with exception of sights. Receiver has two screw holes in rear left side for attaching rear peep sight. One screw has a knurled head and peep hole interchangeable with peep disc when a larger aperture is desired. Elevating adjustment is made by loosening knurled binding screw in left side and swinging rear end of sight to proper graduation on scale, then tighten screw. Windage adjustment is made by loosening knurled peep disc and sliding to right or left to desired graduation, then tighten peep disc.


Rear Sight Windage Plate Screw
Rear Sight Windage Plate
Rear Peep Sight Hub
Rear Peep Sight Disc, Small Aperture
Rear Sight Base
Rear Sight Elevating Plate
Rear Sight Elevating Plate Screw
Front Sight Ramp
Rear Sight Base Screw
Rear Peep Sight Disc, Large Aperture
Rear Sight Elevating Indicator

MODEL 550-1 AUTOLOADING RIFLE
COMPONENT PARTS



Cleaning Action: First, see that gun is neither loaded nor cocked. Remove barrel and receiver from stock. Unscrew receiver plug at rear end of receiver. Pull action spring assembly from receiver (keeping parts assembled as removed). Pull back bolt handle as far as possible and lift bolt handle from bolt. Slide bolt from receiver. Unscrew take-down screw bushing from bottom of receiver. Make sure carrier is in down position and push magazine tube into receiver as far as possible. Reach into ejection port with small screw driver and pry out recoiling chamber at extractor slots or jar out chamber by tapping rear end of receiver on some solid surface. Action can now be easily cleaned.

Reassemble Action: Replace recoiling chamber through ejection port. (Be sure to align feeding ramp with its clearance slot in the receiver insert.) Push magazine tube forward until front end of insert is flush with front end of receiver and replace take-down screw bushing. With carrier in upward position and trigger pulled back, replace bolt in receiver. (Be sure firing pin is in bolt.) Line up bolt handle hole in bolt with hole in rear end of bolt handle slot in receiver. With safety in forward or "Off" position pull back on trigger and with flat of bolt handle in upward position push bolt handle into hole in bolt as far as possible. Release trigger and push bolt handle fully forward. Replace action spring assembly in bolt making sure that main spring plunger has entered socket in rear of bolt. Push assembly forward to engage threads on bolt plug with receiver (keep springs aligned with center of hole in receiver when compressing). Screw bolt plug in place until ratchet teeth engage with bolt plug retainer.

CAUTION: If short cartridges are used to any great extent, care should be taken to clean the chamber of the barrel after shooting as a deposit of lead accumulates at the forward end of the chamber which, if left, will not permit the use of long rifle cartridges afterward until the deposit is removed.

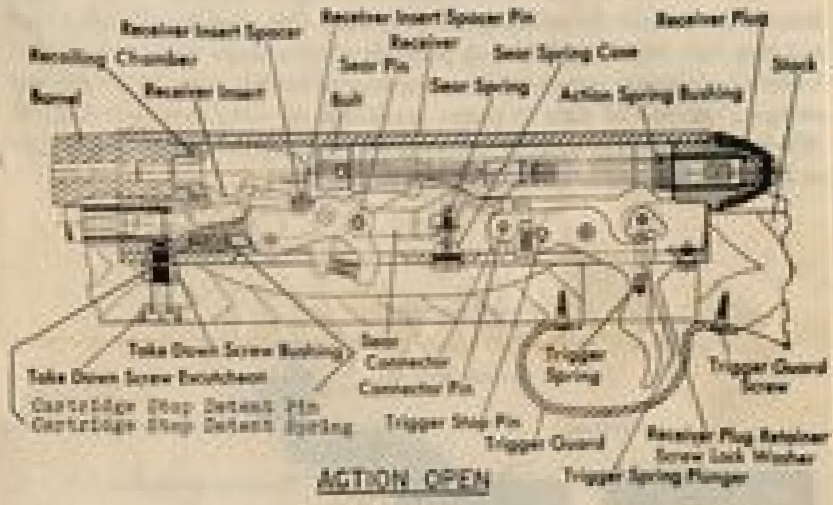
The above condition is true in the case of any .22 caliber rifle chambered for long rifle cartridges.

CARE OF RIFLE

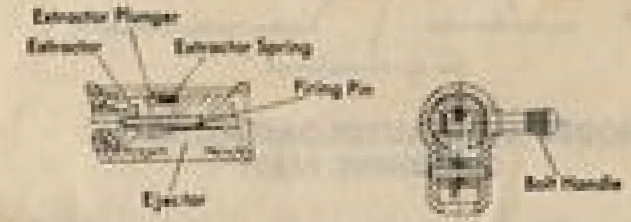
Exclusive use of Remington Ammunition with KLEANBORE Priming or Peter's Ammunition with RUSTLESS Priming will reduce the amount of care necessary to keep the rifle in good condition. These cartridges are non-corrosive and will not cause rust or corrosion. With jacketed bullets cleaning is unnecessary, other than passing an oily rag through the bore to protect it against extreme moisture or when the gun is laid away for some time. Remington Gun Grease and Remington Oil are prepared especially for this purpose.

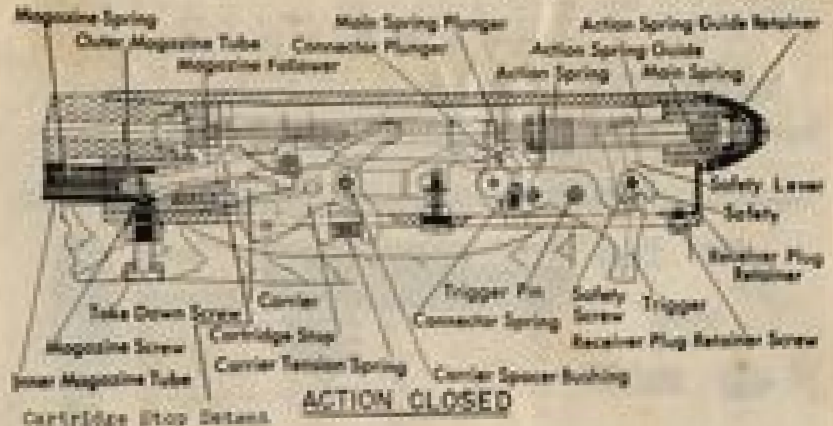
However, if corrosive ammunition is used, clean bore immediately after shooting to prevent residue from rusting or pitting the bore. Cleaning can be done by scrubbing bore with cloth or bristle brush saturated with Remington Powder Solvent. If this is not available, pour one pint of boiling water through barrel to dissolve residue. Use small funnel to prevent spilling. Wipe clean and dry, then lubricate with Remington Oil to prevent rusting. Repeat wiping and oiling again in a day or two.

Interior of barrel should be cleaned free of grease before firing to prevent a swelled bore or injury to barrel.



ACTION OPEN





ACTION CLOSED